



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

005148

D117-762-011
Job Sheet 181938



Part No: D117-762-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/13/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI9771 REV A, IIN-D117-762 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA DD verified by:ec IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP REV:E 15.06.11 IIN REV.D DD VERF:JLM IPP REV:F 17.01.17 PER CHG004 (dsi9771) DD VERF:JLM IPP REV:G 17.08.16 PER CHG005 DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	1 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging1-1		
120	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC4		
130	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs	8/31/18	8/31/18	0.00	1.52	DC		
140	QC21-FG	1 Ea	8/31/18	8/31/18	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP D117-762-011 Location :FG081
Descriptions: 135 - Photocopy bluefile & type labels per PPP D117-762-011 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6C52A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103384
D3512-041	Wearplate	2 Ea (2 ea)	90-Start up Operation	5109370
D5300-1	GHL Bushing	2 Ea (2 ea)	90-Start up Operation	5110374
D5301-1	GHL Plug	2 Ea (2 ea)	90-Start up Operation	5056113
MS21043-6	Nut	2 Ea (2 ea)	90-Start up Operation	5084836
D117-762-041	Replacement Skidtube	1 Ea (1 ea)	110-Packaging	5102524

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN6C52A	2	0	0
	D3512-041	2	7	0
	D5300-1	2	9	0
	D5301-1	2	12	0
	MS21043-6	2	276	0
110-Packaging	D117-762-041	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Work Order update only ☐

Work Order _____ Part: _____ NC _____ Date: _____ DART AEROSPACE Container No: S110744 Part: D117 - 762 - 011 Job No: 181938 Serial No/Batch: S110744 Revision: A / E Inspector: _____ Exp Date: _____ Instructions: FAA STC SR01853SE 15/10/2016 STC LoA RDIMS - 4374899 08/0	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="width: 40%;">DISPOSITION</th> <th colspan="5">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td>Rework ☐</td> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Scrap ☐</td> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Use-as-is ☐</td> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Suspected Unapproved ☐</td> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> r Deviation _____ </td> <td style="width: 50%;"> QTY Effective : _____ </td> </tr> <tr> <td colspan="2" style="height: 200px; vertical-align: top;"> Disposition Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____ </td> </tr> </table>	DISPOSITION	AGAINST DEPARTMENT/PROCESS					Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		r Deviation _____	QTY Effective : _____	Disposition Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
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Root Cause	FAULT CATEGORY
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____	

5.0 PARTS LIST

5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*NAS1149C0332R	WASHER (OR AN960C10L)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*NAS1149C0332R	WASHER (OR AN960C10L)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*NAS1149C0332R	WASHER (OR AN960C10L)
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-762 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-762 REV. 4

REF FAA STC: SR01853SE

REF: TC LETTER OF ACCEPTANCE RDIMS-4374899

REF EASA STC: EASA.10017063

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to replace the ground handling lugs (D3864-1 Bushings, AN6C51A Bolts and MS21043-6 Nuts) on the D117-762-XXX Skid tubes with a structurally superior lug design (D5300-1 Bushings, D5301-1 Plugs, AN6C52A Bolts, MS21043-6 Nuts) as shown in Figure 1. The new hardware will be included in D117-762-011 @ CHG 004 and subsequent.

2.0 INSTALLATION

For D117-762-011 @ CHG 004 and subsequent, the ground handling hardware should be installed as follows:

- 2.1 Loosely install (qty 2) D5300-1 GHL Bushing & (qty 2) D5301-1 GHL Plug wet with Proseal 890 or MIL-S-8802 Class B2 Sealant in location shown in Figure 1.
- 2.2 Install (qty 2) AN6C52A Bolts and (qty 2) MS21043-6 Nuts in accordance with Figure 1. Clean up squeezed out Proseal and apply fillet seal around D5300-1 & D5301-1.
- 2.3 Torque AN6C52A Bolts 160 - 190 in-lbs (18.1 - 21.5 N-m).

3.0 PARTS LIST

For D117-762-011 @ CHG 004 and subsequent, the Part List in IIN-D117-762 and ICA-D117-762 is modified as follows:

IS

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	D117-762-011	SKIDTUBE INSTALLATION
50	2	AN6C52A	BOLT
51A	2	D5300-1	GHL BUSHING
51B	2	D5301-1	GHL PLUG
52	2	MS21043-6	NUT

REFERENCE ONLY

A	NEW ISSUE	RF	17.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE, LTD EUGENE, OR	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV.A
MFG. APPR.	N/A	DSI 9771	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.		GHL UPGRADE KIT	NTS
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